

FAASA 119 baskets

Dart Aerospace Ltd.

Date: Tuesday, 2/26/2008 8:01:10 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET (A119) ARMS  
 Job Number : 37621  
 Estimate Number : 12443  
 P.O. Number :  
 This Issue : 2/26/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1 / Type : SMALL / MED FAB  
 Previous Run : 31629  
 Written By :  
 Checked & Approved By : 080226  
 Comment : EST rev A 05.06.06 preliminary EC  
 est rev b 06.07.31 re-design EC  
 est rev C 07.04.09 revB dwg EC

Part Number : D3518041  
 Drawing Number : D3518 REV.B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 3/14/2008 Qty: 14 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D23245	Strap
Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s) Strap batch: <u>1336749 B</u> <u>510</u>		
2.0	D35181	STAINLESS STEEL BALL JOINT ROD END
Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s) FWD ARM Batch: <u>1331683</u> <u>54</u>		
3.0	D35183	AFT ARM
Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s) AFT ARM Batch: <u>1331684</u> <u>(8x)</u> <u>1337641</u> <u>54</u>		
4.0	AN313A	Bolt
Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s) Bolt Batch: <u>112490</u> <u>(21x)</u> <u>104746</u> <u>(7x)</u> <u>50</u>		
5.0	AN316C6R	Nut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s) Nut batch: <u>117280</u> <u>(5x)</u> <u>19020</u> <u>(9x)</u> <u>8/3/11</u> <u>50</u> <u>(14x)</u>		



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: LD Date: 08/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

Date: Tuesday, 2/26/2008 8:01:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 37621

Part Number: D3518041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Batch: M106552

50

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s)

Nut

Batch: M106242

8/3/11- 50

(14x)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3518

FF 08-03-12

(14)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28/03/12 (x14)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Part # D3518-041 using fine point permanent ink marker and Stock

Location: 272

8/3/13 50 14

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/03/14

(14)

Job Completion



2008/3/13

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

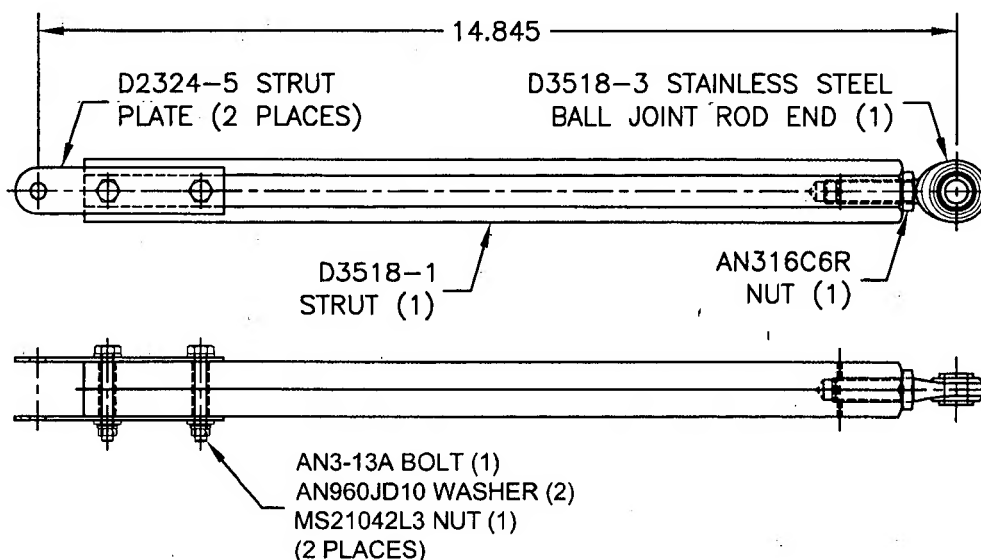
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



### D3518-041 STRUT ASSEMBLY

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

#### NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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NO. **37621**

RELEASED

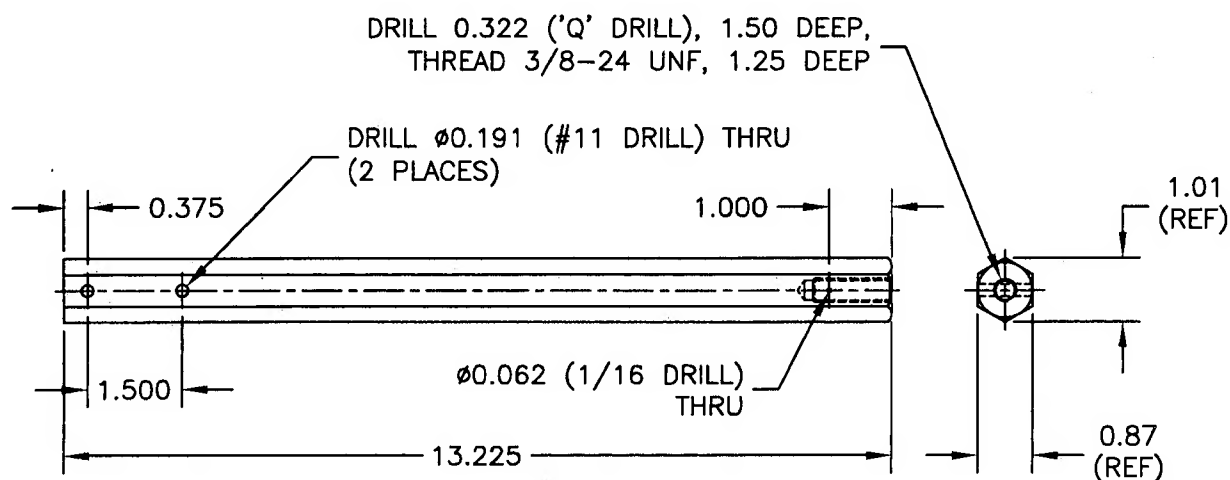
06.11.17 *[Signature]*

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3



### D3518-1 STRUT

#### NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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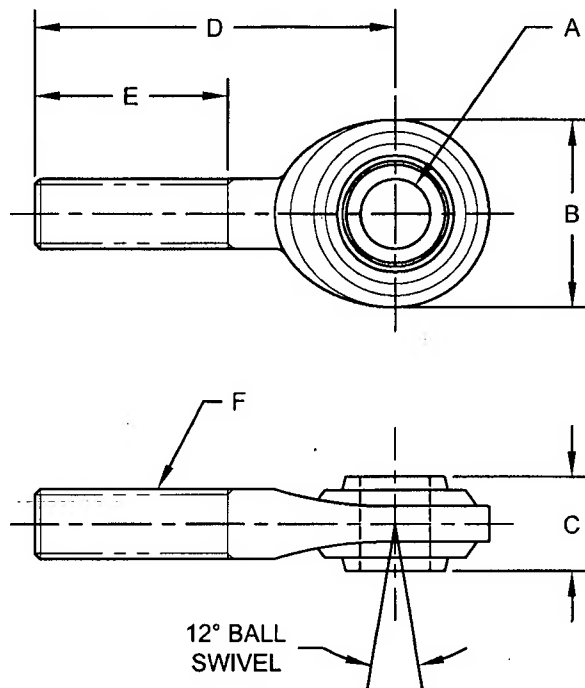
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:1

## SPECIFICATION CONTROL DRAWING



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NO. *37621*

DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

\* Indicated load is Static Radial Load Capacity in lbs

### NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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